

# Work Order ID 80565

\*80565\*

Page 1

February-23-12 11:19:17 AM

Item ID: D4092-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 23/02/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 05/03/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/23 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4092	B								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

EP 2/02/23 (2)

EP 2/02/23 (2)

M 12 02 23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*80565\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

\*2\*

\*2\*

**Customer:**

**Reference:**

Run Start \*NR1\*

Date:

**Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

**Insp.  
Stamp**

Identify as per dwg & Stock Location:\_\_\_\_\_

0.00

**\*130\***

## Packaging

## Memo

0.00

## Packaging

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

R 12/2/24 (2)

M.C.J 12/02/24

120224 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

February-23-12 11:19:22 AM

Page 1

Work Order ID: 80565

\*80565\*

Parent Item: D4092-042

\*D4092-042\*

Parent Item Name: Maintenance Step Assembly

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4092-1  
\*D4092-1\*  
Maintenance Step

Manufactured No

Each 1.0000

\*\*

Location

Loc Qty

Loc Code

ST241A

1

74303

1

D4093-1  
\*D4093-1\*  
Bracket

Manufactured No

Each 5.0000

\*\*

Location

Loc Qty

Loc Code

ST124

5

77853

5

D4093-3  
\*D4093-3\*  
Bracket

Manufactured No

Each 11.0000

\*\*

Location

Loc Qty

Loc Code

ST124

11

77850

11

D4093-5  
\*D4093-5\*  
Bracket

Manufactured No

Each 34.0000

\*\*

Location

Loc Qty

Loc Code

ST124

34

80085

14

80226

20

EP 52/02/23  
B77852 (4k)

EP 52/02/23

EP 52/02/23

EP 52/02/23

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

February-23-12 11:19:22 AM

Page 2

Work Order ID: 80565

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

\*80565\*

\*D4092-042\*

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS24694-S54

Purchased

No

Each

128.0000

4

\*MS24694-S54\*

Screw

\*\*

*Ep 12/02/23*

Location

Loc Qty

Loc Code

ST289A

128

120142

28

120361

100

*4*

MS24694-S55

Purchased

No

Each

125.0000

16

\*MS24694-S55\*

Screw

\*\*

*Ep 12/02/23*

Location

Loc Qty

Loc Code

ST289A

125

119307

49

120142

76

*16*

*S* MS24694-S56

Purchased

No

Each

57.0000

4

\*MS24694-S56\*

SCREW

\*\*

*Ep 12/02/23*

Location

Loc Qty

Loc Code

ST289A

57

104407

7

120142

50

*4*

NAS1149D0332J

Purchased

No

Each

2,359.000

24

\*NAS1149D0332.I\*

Washer

\*\*

*Ep 12/02/23*

Location

Loc Qty

Loc Code

ST298

2359

105793

12

110985

4

117087

89

119042

284

119717

970

120644

1000

*24*

February-23-12 11:19:22 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

February-23-12 11:19:22 AM

Page 3

Work Order ID: 80565

\*80565\*

Parent Item: D4092-042

\*D4092-042\*

Parent Item Name: Maintenance Step Assembly

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

Each

4,190.000

24

\*MS21042L3\*

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

4190

117441

16

117885

32

118451

5

118927

3

119017

3862

119075

272

EP 12/02/23  
24

**Dart Aerospace Ltd**

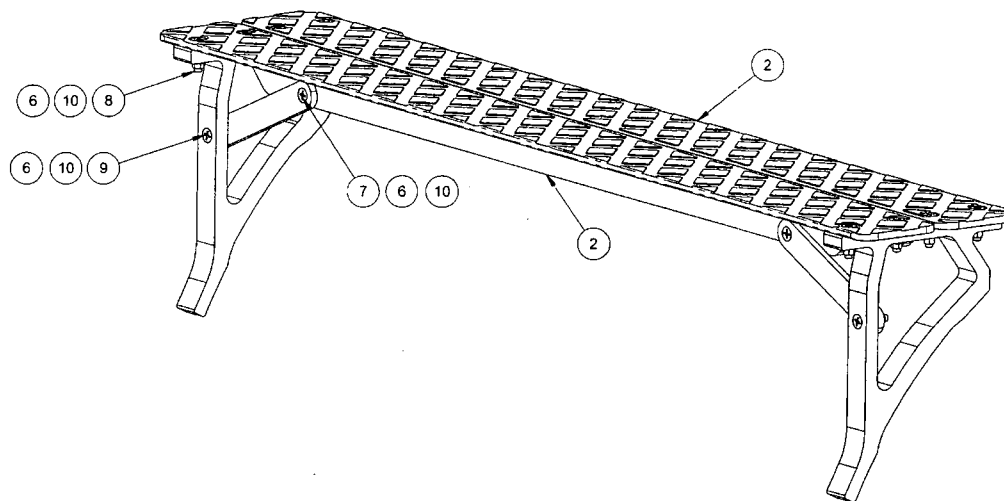
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4092-041 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

UNION  
SUBJECT  
WORK  
NO. 80565 H.C.J  
12/02/23

RELEASED  
2011-09-22  
JWW

B	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

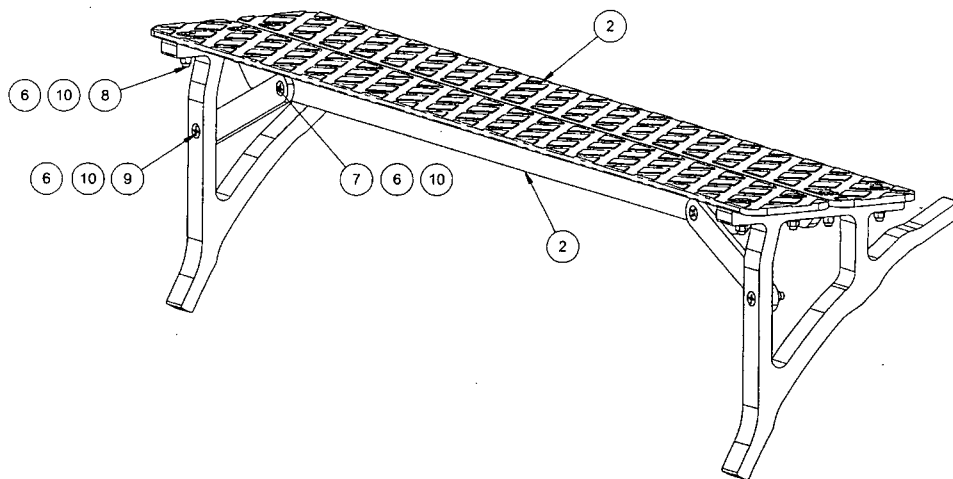
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4092-042 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

80565

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2011-09-23  
JW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4092	REV. B
MFG. APPR.	RF	TITLE	SHEET 2 OF 6
APPROVED	RF	MAINTENANCE STEP ASS'Y	SCALE NTS
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DATE	11.07.27		

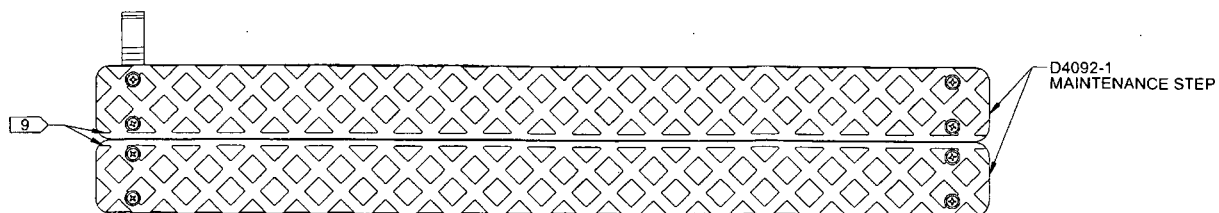
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

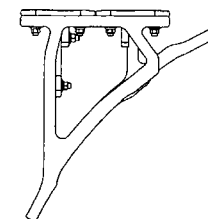
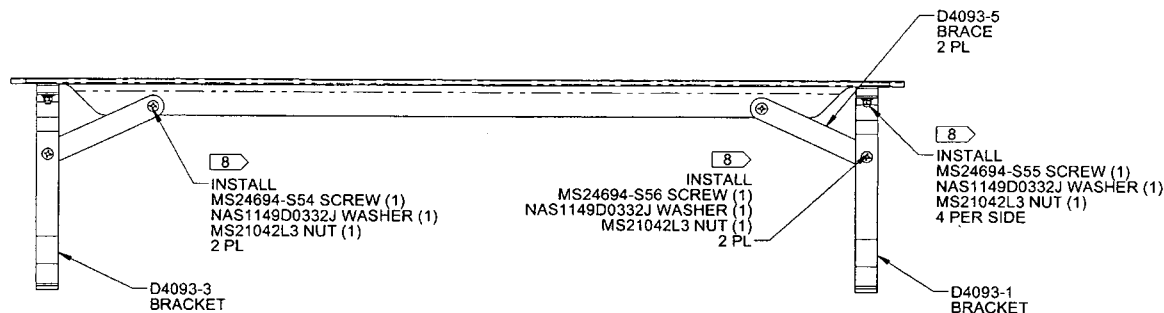
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80565



# **D4092-041 MAINTENANCE STEP ASSEMBLY**

RELEASED  
2011-09-22

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 3 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

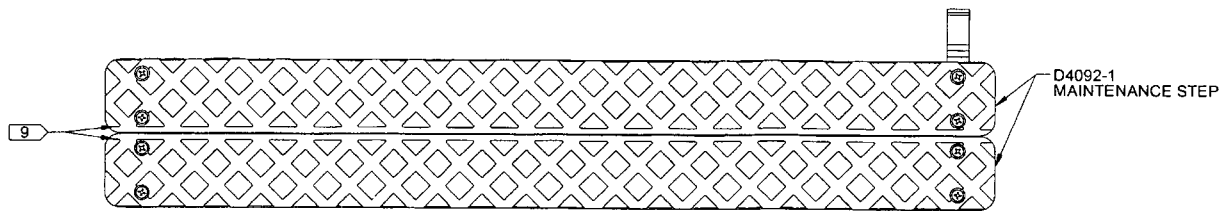
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

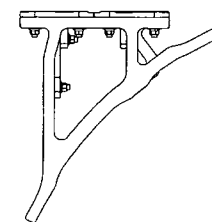
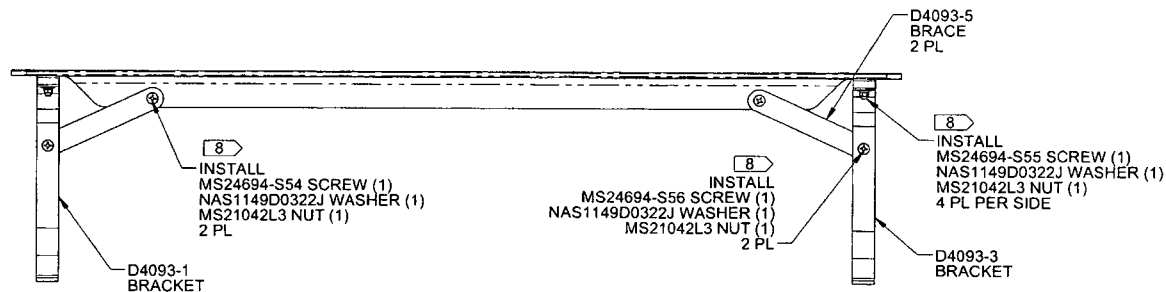
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





80565



# **D4092-042 MAINTENANCE STEP ASSEMBLY**

RELEASED  
2011-09-22

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4092	SHEET 4 OF 6
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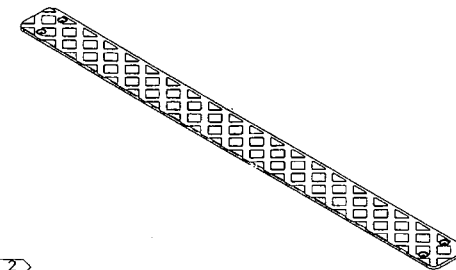
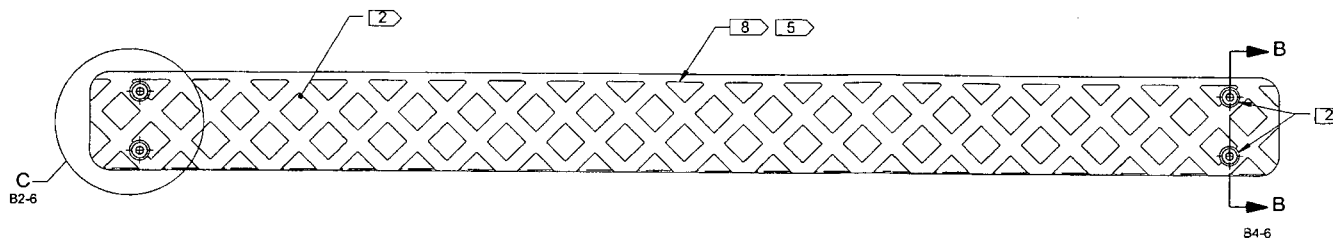
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

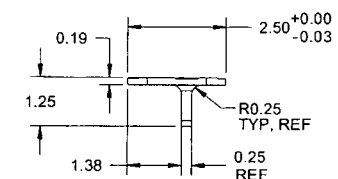
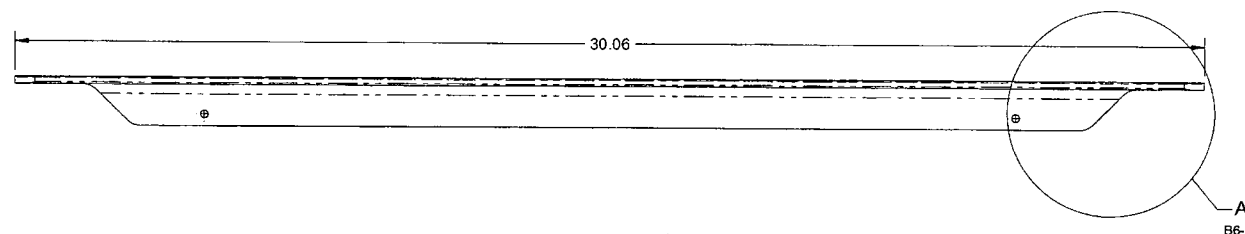
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80565



# **D4092-1 MAINTENANCE STEP** (MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

## **NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 5 OF 6
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

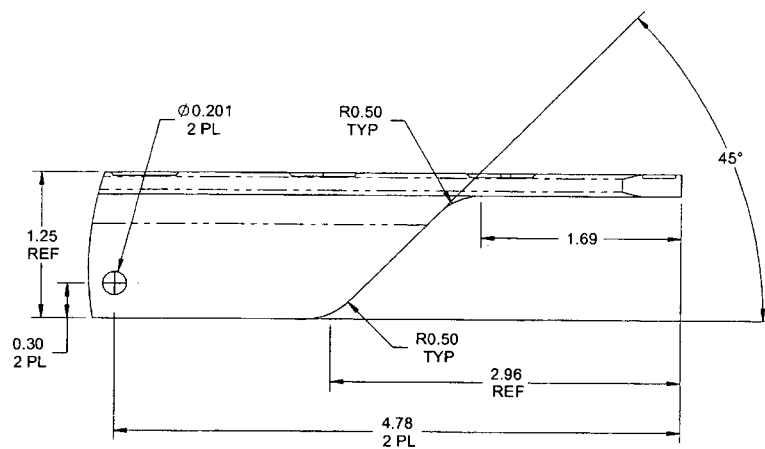
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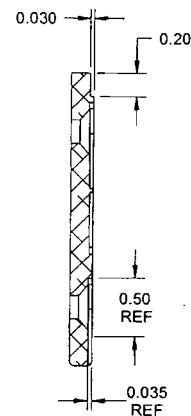
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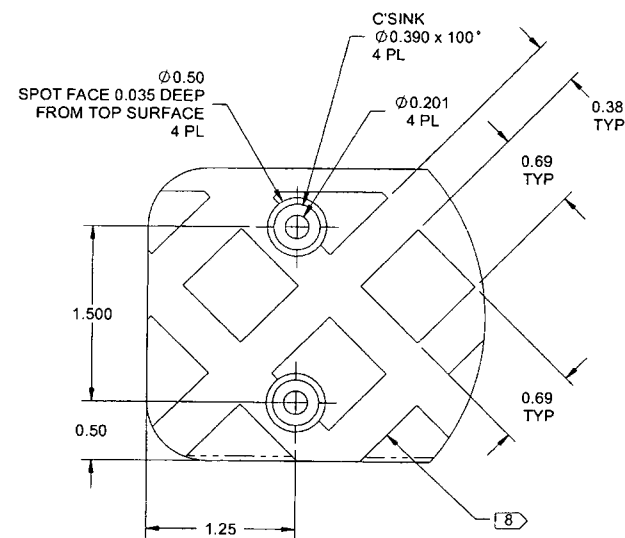
80565



**DETAIL A**  
SCALE 3X, TYP



**SECTION B-B**  
SCALE 3X, TYP



**DETAIL C**  
SCALE 3X, TYP

**RELEASED**  
2011-09-22

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	1/20	DRAWING NO.	REV. B
MFG. APPR.	2/1	<b>D4092</b>	SHEET 6 OF 6
APPROVED	1/20	TITLE	SCALE
DE APPR.	1/20	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries